

Work Order ID 129747

February-23-15 10:19:32 AM

129747

~~PRELIMINARY ISSUE~~ Page 1

Item ID: D350-604-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Rear Locker Extender

Stop *NS2*

Start Date: 2/05/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/23/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 15-02-24 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2273	X K								
D350-604-041	C 4/15/16								

100 Document Control 0.00

100

DC DOCUMENT CONTROL

0.00

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile and create labels per PPP D350-604-041

CHG 008

CHG 009

SCRAP

DQA:

Date: 15/06/11



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/06/11

Work Order update only ☐

Work Order: <u>129747</u>	DISPOSITION		✓ AGAINST DEPARTMENT/PROCESS			
Part No. <u>D350-604-041</u>	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☒	
NCR No. <u>15-5081</u>	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☒	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☒		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☒	15.03.16	100	1	PART DOES NOT CONFORM D2273 is now made by FDC Composites PC D2273 Rev.K	DAS 12 9-89 15.03.16	D350-604-041 is now at CHG 009 SEE ATTACHED D2273 REV.K	DAS 12 9-89 15.03.16	DAS 9 9-89 15.03.16	DAS 9 9-89 15.03.16
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

✓ FAULT CATEGORY

Landing Gear		General			
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions	☐ Pressure/Forced	
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Set-up	
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect	☐ Temperature/Cure	
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing	☐ Weld	
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved	☐ Wrong Stock Pulled	
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong	☐ Other	
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge		
☐ Inspection Strip in Tube	☒ Drawing	☐ Misread			
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set			
☐ Turning Sequence	☐ Finish	☐ Out of Calibration			
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence			

Work Order ID 129747

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Page 2

Item ID: D350-604-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Rear Locker Extender
 Start Date: 2/05/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110	PURCHASING	0.00							
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110

Purchasing

Purchasing

Memo

Issue P/O: 27634
 Description: D350-604-041 Rear locker extender.
 Manufacture as per dwg D2273
 Supplier: Carbon-by-Design
 Certification of Conformity and process sheet from Carbon-by-Design is required.

EXTREME CARE MUST BE TAKEN TO PROTECT THE SURFACES OF THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

120	Receive & Inspect for Damage & Mat'l Certs	0.00							
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120

Packaging

Packaging

Memo

Ensure a copy of Certification of Conformity and process sheet from Carbon-by-Design is attached.

DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM

LC 15-03-03

1X SP15-03-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>129747</u> Part No. <u>D350-604041</u> NCR No. _____	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☒</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☒	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☒																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				outside finish					
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☒ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

Work Order ID 129747

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Page 4

Item ID: D350-604-041

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Item Name: Rear Locker Extender

Stop ***NS2***

Start Date: 2/05/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/23/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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155

Pick Kit

0.00

155

Packaging

Memo

0.00

Packaging

DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM

158

QC4- 100% Inspect kits for completeness

0.00

158

QC

Memo

0.00

Quality Control

160

Packaging

0.00

160

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-604-041

Location: _____

PPP Rev: _____

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 129747***129747***

Page 5

Item ID: D350-604-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Rear Locker Extender

Stop ***NS2***

Start Date: 2/05/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/23/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

POSITIVE RECALLEFFECTIVE 503.03 AUTH U
RELEASED 40 DATE 5/3/16

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

February-23-15 10:19:31 AM

Page 1

Work Order ID: 129747

129747

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 2/05/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF IPP REV:R
12.02.07 AS PER ECN12-521 DD verf:JLM IPP REV:S 12.04.04
AS PER DWG REV.B DD VERF:EC IPP REV:T 13.09.12 as per
CHG006/ECN13-616 DDVERF:JLM IPP REV:U 14.05.28 as per
chg008/ecn14-563 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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2600-6		Purchased	No			140	Each	204.0000	4	4			
2600-6													
Camlock Stud													

Location	Loc Qty	Loc Code
ST569	204	
M128398	4	
M129790	100	
M131296	100	

2600-LW		Purchased	No			140	Each	187.0000	4	4			
2600-1 W													
Washer, Camlock Retaining													

Location	Loc Qty	Loc Code
ST569	100	
m131296	100	
ST570	87	
m128429	87	

D2268		Manufactured	No			140	Each	14.0000	1	1			
D2268													
Placard													

Location	Loc Qty	Loc Code
ST006	14	
110734	2	
127457	12	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 129747

129747

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 2/05/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

D2269	Manufactured	No	155	Each	15.0000	1	1
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D2269

Placard

Location

Loc Qty

Loc Code

ST006

15

111345

3

127708

12

D350-604-041P

Purchased No

110 Each

0.0000

1

1

D350-604-041P

Rear Locker Extender

D5062-041

Manufactured No

155 Each

7.0000

1

1

D5062-041

Bracket Assembly

Location

Loc Qty

Loc Code

ST144

7

121957

7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

TABLE 1

POSITION	MATERIALS
1	TOOL SURFACE
2	GEL COAT
3	7725 FIBER GLASS
4	3/4 oz CHOPPED STRAND MAT
5	7725 FIBER GLASS
6	7725 FIBER GLASS
7	PRIMER

TABLE 2

POSITION	MATERIALS
1	TOOL SURFACE
2	GEL COAT
3	7725 FIBER GLASS
4	3/4 oz CHOPPED STRAND MAT
5	7725 FIBER GLASS
6	7725 FIBER GLASS
7	7725 FIBER GLASS
8	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

D2273 REAR LOCKER EXTENDER

TABLE 3

MATERIAL USED	DESCRIPTION
GEL COAT	4314-001 DURA FR WHITE GELCOAT
FIBER GLASS MAT	OWENS CORNING OR EQUIVALENT 3/4 oz CHOPPED STRAND MAT
FIBER GLASS CLOTH	HEXCEL 7725 FIBER GLASS
RESIN SYSTEM	PCCR 7624425UPR
PRIMER	DEFT MIL-PRF-85582E TYPE 1, CLASS 1

NOTES:

- 1) MATERIAL: SEE TABLE 3
- 2) FINISH: SEE TABLES 1, 2, & 3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 5.5 - 7.5 lbs
- 8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 9) LAYUP USING DT9871 MOLD. WET LAYUP WITH BAG/VACUUM
- 10) TRIM & DRILL PER DT9805. OPEN HOLES TO Ø0.188
- 11) CONSTRUCTION: SEE TABLES 1 & 2
- 12) MATTE TO HOLD DOWN CORNERS AS REQUIRED

21.38
REFØ0.257
4 PL
1025.75
REF17.80
REFA
C2-1

SEE TABLE 1

SEE TABLE 2

SECTION A-A

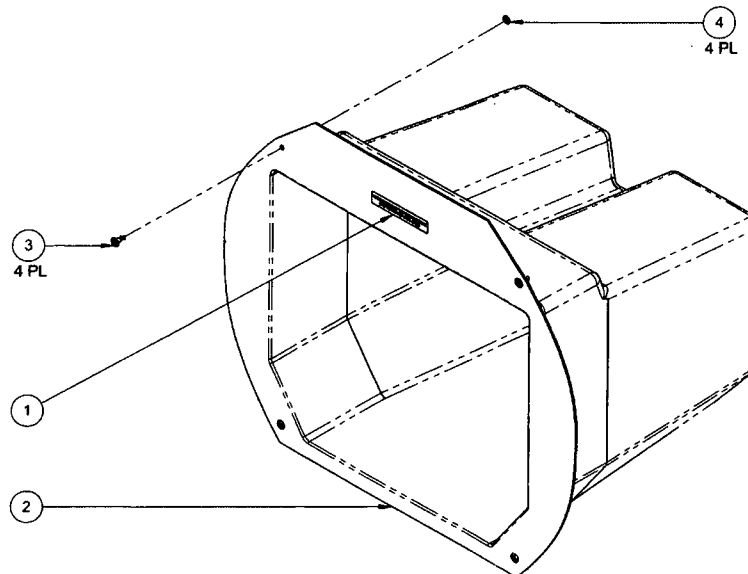
C4-1

RELEASED
2016-01-03

J	CHANGED GELCOAT TO 4314-001 DURA FR WHITE	ML	13.12.10
I	CHANGE GELCOAT TO POLYCOR 2330PAWK745	SFM	13.08.13
H	CHANGE MATERIAL & MANUFACTURING PROCESS	DC	13.03.15
G	ADD MANUFACTURING OPTION B, ZN BS-1	DC	12.08.08
F	PRIMER LE 3404-S/LE 1175-S WAS 1144-S, ZN A8-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 844W005 GELCOAT TO 2330PAWK745 GELCOAT, ZN A7-1. UPDATED DWG TO CURRENT STANDARDS	DC	12.02.02
D	REMOVE EPOCAST, ADD SURFACE FINISH	CP	02.04.01
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	06.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DRAWING NO. D2273 REV. J SHEET 1 OF 1	
DATE	13.12.10	TITLE 350 REAR LOCKER EXTENDER NTS SCALE	
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SEE
Rev. K

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
	X	D350-604-041	REAR LOCKER EXTENDER ASSEMBLY
1	1	D2268	PLACARD
2	1	D2273	REAR LOCKER EXTENDER
3	4	2600-6	CAMLOCK STUD
4	4	2600-LW	RETAINING WASHER



D350-604-041 REAR LOCKER EXTENDER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 5.5 to 7.5 lbs
- 8) INSTALL D2268 PLACARD IN LOCATION SHOWN, CENTERED ON FLANGE

C	REMOVE D2728-1, D2729-1 DECALS (ZN C5-1) REVISED RELATED NOTES, UPDATED PART WEIGHT	ML	13.12.16
B	INCORPORATE DSI 9470 (ZN D7-1), UPDATE DWG TO CURRENT STANDARDS, ADD D2728-1 PLACARD AND ORIENTATION NOTE (ZN C3-1), ADD D2729-1 (ZN C5-1).	DC	12.02.07
A	NEW ISSUE	CP	02.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D350-604-041	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	RE ASSY	NTS
DATE	14.01.02	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27634**

Purchase Order Date 3/03/15

PO Print Date 3/03/15

Page Number 1 of 2

Order From :

VC-FDC01

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450-357-1344

Ship To Contact

Ship To Phone

Ship Via: BEST WAY

Ship Acct:

Buyer

Linda Lacelle

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D350-604-041P MANUFACTURE PER DRWG D2273 B129749	Rear Locker Extender	3/13/15 Yes 3/13/15		1.00 Each	\$620.00	\$620.00
Line Total:							\$620.00
2	D350-604-041P AS ABOVE B129748	Rear Locker Extender	3/13/15 Yes 3/13/15		1.00 Each	\$620.00	\$620.00
Line Total:							\$620.00
3	D350-604-041P AS ABOVE B129747	Rear Locker Extender	3/13/15 Yes 3/13/15		1.00 Each	\$620.00	\$620.00

Note:

3/03/15

SP 15-03-13

DC Composites inc.
15, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tél. : 450 357-1344

Bon de livraison 13/03/2015

Commande : 2096
Référence : PO #027634

Client : Dart

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Expédier à

Même

Tél. : 1 613 632-9577

No item	Description	Qté	Qté livrée	Qté B/O
D350-604-041P	REAR LOCKER EXTENDER PO item: 026734/1 Lot: 2015-03-10	1	_____	_____
D350-604-041P	REAR LOCKER EXTENDER PO item: 026734/2 Lot: 2015-03-11-1	1	_____	_____
D350-604-041P	REAR LOCKER EXTENDER PO item: 026734/3 Lot: 2015-03-11-2	1 ✓	_____	_____
D350-604-041P	REAR LOCKER EXTENDER PO item: 026734/4 Lot: 2015-02-12	1	_____	_____

DAS
9
9-89

SP/15-03-16

Transport : _____

Réf. : _____

Nb colis : _____

Marchandise reçue : _____



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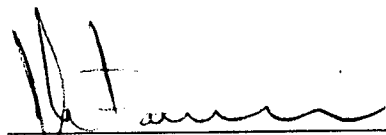
CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: PO27634

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Drawing number</u>	<u>Description</u>	<u>Lot</u>
1	1	D650-604-041P	D2273 Rev J	350 Rear Locker Extender	2015-03-10
2	1	D650-604-041P	D2273 Rev J	350 Rear Locker Extender	2015-03-11-1
3	1 ✓	D650-604-041P	D2273 Rev J	350 Rear Locker Extender	2015-03-11-2
4	1	D650-604-041P	D2273 Rev J	350 Rear Locker Extender	2015-02-12

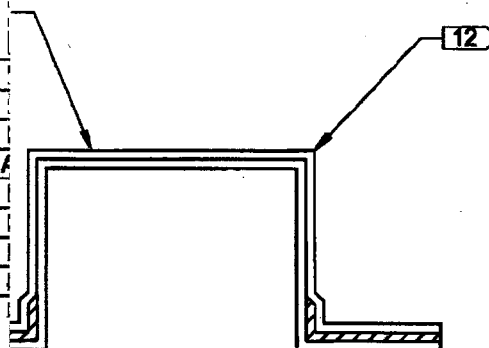
I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.


Jules Fournier, BDI, Quality Manager

Date: 2015-03-13

TABLE 1 

POSITION	MATERIALS
1	TOOL SURFACE
2	GEL COAT
3	3/4 oz CHOPPED STRAND MA
4	7725 FIBER GLASS
5	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

**TABLE 2** 

POSITION	MATERIALS
1	TOOL SURFACE
2	GEL COAT
3	3/4 oz CHOPPED STRAND MA
4	7725 FIBER GLASS
5	7725 FIBER GLASS
6	7725 FIBER GLASS
7	7725 FIBER GLASS
8	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

SECTION A-A

PER FDC COMPOSITES PROCESS	CP	15.03.12
AT TO 4314-001 DURA FR WHITE	ML	13.12.10
T TO POLYCOR 2330PAWK745	SFM	13.08.13
L & MANUFACTURING PROCESS	DC	13.03.15
RING OPTION B, ZN B5-1	DC	12.08.08
LE 1175-S WAS 1144-S, ZN A6-1	DC	12.02.27
GE FINISH FROM 944W005 GELCOAT TO COAT, ZN A7-1. UPDATED DWG TO ARDS.	DC	12.02.02
T, ADD SURFACE FINISH	CP	02.04.01
L, LAYUP, AND TOOLING	RF	02.01.30
	MM	98.05.27
DESCRIPTION	BY	DATE

NOTES:

- 1) MATERIAL: SEE TABLE 3
- 2) FINISH: SEE TABLES 1, 2, & 3
- 3) TOLERANCES: PER DART QSI 018 UNLESS C
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 5.5~ 7.5 lbs
- 8) LAMINATE PER DART QSI 006. LAMINATION
- 9) LAYUP USING DT9871 MOLD. WET LAYUP W
- 10) TRIM & DRILL PER DT9905. OPEN HOLES T
- 11) CONSTRUCTION: SEE TABLES 1 & 2
- 12) MATTE TO HOLD DOWN CORNERS AS REC

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D2273

REV. K

SHEET 1 OF 1

TITLE

350 REAR LOCKER EXTENDER NTS

SCALE

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# LOT	2015-03-09 -1
# SÉRIE(ID)	DAE001-014

Nom de Gamme :	Rear locker extender - DART
# de Gamme (et rev.) :	DAE001 Rev. A
Nom pièce - Client :	350 Rear locker extender - DART AEROSPACE
# de Dessins (et rev.) :	D2273 Rev. J

Fiche suiveuse

[10-60]	Préparation	Moule, Espace de travail, Matière premières, Consommables	2015-03-09 ny	2015-03-09 ny
[70-90]	Finition/Peinture	Appliquer Gel coat, Inspecter	2015-03-11 SP	2015-03-11 SP
[100-150]	Laminage	Laminer, Démouler, Inspecter	2015-03-11 CBP	2015-03-11 SP
[160-220]	Usinage	Percer, Découper, Ébavurer, Inspecter, Sabler	2015-03-12 CHM	2015-03-12 CH
[230-240]	Finition/Peinture	Primer, Inspection	2015-03-12 ny	2015-03-12 SP
250	Expédition	Emballer, Expédier		

Gamme préparé par :

Guillaume G. Jasmin

Gamme révisée par :

Francis Lavigne-Larente

Gamme vérifiée par
(Chefs d'équipe) :

Maxime Gagné

Gamme approuvée par :

Maxime Gagné

Date d'émission :

2015-01-14

Toutes les étapes et les informations requises de cette gamme ont été complétées et remplies



Informations à remplir :

Cases grises pâles

Inspection :

Matières premières

Résine	501-409	2015/04/08	Dion 7704
Norox (Résine)	409-124	2015/04/17	MEKP-9
Norox (Gel coat)	409-124	2015/04/17	MEKP-9
Gel coat white	702015010031	2015/04/17	Polycor 2330PAWK745
Mat ¾ oz/pi²	14070212	N/A	¾ oz Chopped Strand Mat (Owens Corning Or Equivalent)
Fibre de verre 7725	1288798	N/A	Hexcel 7725 Fiber Glass
Apprêt (Primer) (Vert)	14742	2016-08	Tempo 4500-PB-23G (Vert)
Durcisseur pour apprêt (hardener)	14216	2016-04-28	Tempo 4500-C-23

Moule : MOU306 ou MOU307	FMS	Sarrau
Pompe à vacuum	55NC	Lunettes de sécurité
Jig de découpe et perçage : GAB350	Peel ply	Soulier de protection
	Film perforé	Gants
	Bleeder breather	Masques à cartouches
	Bag big blue	
	Ruban scellant (Dum Dum)	

Annexe 1
Formulaire de résine (RES-DAR001)

MPS-300-93-31-007-NC	Démoulage 55NC
MPS-300-93-31-058-A	Composite part inspection
MPS-300-93-31-020-B	Edge finish after trimming
MPS-300-93-31-097-NC	Epoxy - Polyamide primer
MPS-300-93-31-084-NC	Protection et entreposage des pièces

Suivi des révisions

A	Révision d'une OP inspection, Ajout nouveaux moules et retrait d'un type de primer	2015-03-04	Guillaume G.Jasmin

Section A : PRÉPARATION

10	<u>Remplir les informations requises sur la première page (cases grises pâles)</u> • Demander au coordonnateur de production (ID) • Inscrire les heures et les dates d'entrée et de sortie de département		2015-03-09 HJ
20	<u>Découper la fibre et les périssables (Peel ply, sac étanche...) selon l'ANNEXE 1</u> • ACHEMINER et REMPLIR la section « Matière premières » pour : - Fibre de verre 7725 - Mat ¾ oz	Annexe 1	2015-03-09 HJ
30	<u>Préparer la résine selon RES-DAR001 (Gamme de formulation de résine)</u> ACHEMINER et REMPLIR la section « Matière premières » pour : - Résine - Norox	RES-DAR001	2015-03-11 HJ
40	PRÉPARER le moule ☒ Nettoyer et traiter le moule ☒ Poser le Masking tape	Annexe 1 MOU306 ou MOU307	2015-03-11 HJ
50	<u>Si nécessaire, traiter le moule au 55NC</u> • Faire le test de pelage, s'il ne passe pas, appliquer une couche de 55NC et refaire le test.	MPS-300-93-31-007	2015-03-11 HJ
60	PRÉPARER l'espace de travail (pendant l'application du gel coat) ☒ Vérifier et préparer la pompe ☒ Préparer et distribuer les outils ☒ Protéger l'environnement de travail (tables, plancher, etc.) ☒ Vêtir l'équipement de protection personnel ☒ Partir la ventilation		2015-03-11 HJ

Section B : APPLICATION GEL COAT

70	(GEL COAT) : ACHEMINER et REMPLIR la section « Matière premières » pour : • Gel coat		2006/03/10 X 2005/12-11/11 NVA		
80	APPLIQUER le Gel coat (18 - 22 mils) <table><tr><td>Heure d'application</td><td>08:00 - 10:00</td></tr></table>	Heure d'application	08:00 - 10:00	Annexe 1	
Heure d'application	08:00 - 10:00				

Section C : LAMINAGE

110	LAMINER <table border="1"> <thead> <tr> <th>Position</th> <th>Matériel</th> </tr> </thead> <tbody> <tr> <td>10F</td> <td>¾ oz Chopped strand MAT</td> </tr> <tr> <td>20F</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>30F</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>40R</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>50R</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>60R</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>70F</td> <td>7725 Fibre de verre</td> </tr> </tbody> </table> ☐ S'assurer que tous les plis dans le tableau ont été laminés <table border="1"> <tr> <td>Heure début laminage</td> <td>8 h 45 min</td> </tr> <tr> <td>Heure mise sous-vide (sac scellé)</td> <td>10 h 30 min</td> </tr> <tr> <td>Intensité du vide (25 inHg)</td> <td>24 inHg</td> </tr> </table>	Position	Matériel	10F	¾ oz Chopped strand MAT	20F	7725 Fibre de verre	30F	7725 Fibre de verre	40R	7725 Fibre de verre	50R	7725 Fibre de verre	60R	7725 Fibre de verre	70F	7725 Fibre de verre	Heure début laminage	8 h 45 min	Heure mise sous-vide (sac scellé)	10 h 30 min	Intensité du vide (25 inHg)	24 inHg	Annexe 1	2015-03-11 Mantir A.D. <i>[Signature]</i> <i>[Signature]</i>
Position	Matériel																								
10F	¾ oz Chopped strand MAT																								
20F	7725 Fibre de verre																								
30F	7725 Fibre de verre																								
40R	7725 Fibre de verre																								
50R	7725 Fibre de verre																								
60R	7725 Fibre de verre																								
70F	7725 Fibre de verre																								
Heure début laminage	8 h 45 min																								
Heure mise sous-vide (sac scellé)	10 h 30 min																								
Intensité du vide (25 inHg)	24 inHg																								
120	LAISSER POLYMÉRISER la pièce sous vide pendant 2h		2015-03-11 <i>[Signature]</i>																						
130	<u>DÉMOULER et IDENTIFIER la pièce</u> ☒ Écrire le numéro de pièce et la date sur un collant - # de lot (date de début) - # de série ID Ex : (AAAAMMJJ) - (DAE001-XXX) ☒ Placer la pièce sur la table d'inspection	Annexe 1	2015-03-11 <i>[Signature]</i>																						
140	<u>Point d'inspection (inspecteur qualité) :</u> ☐ Identifier la présence de surplus de résine ☒ Identifier la présence de bulles d'air ☒ Identifier la présence de zone sèche ☒ Identifier la présence de plis de fibre	MPS-300-93-31-058	2015-03-12 Inspecteur <i>[Signature]</i> Qualité																						

150	<u>Nettoyer le moule</u> - Enlever la résine durcie tout le tour du moule avec une spatule en plastique pour ne pas endommager le moule <u>Si nécessaire</u>, nettoyer le moule avec un chiffon légèrement humecté de nettoyant à moule (PMC) NE PAS TROP APPLIQUER DE "PMC"	Spatule en plastique	2015-03-12 SP
-----	---	----------------------	------------------

Section D : USINAGE

160	INSTALLER le gabarit de perçage et découpe	GAB350 Annexe 1	2015-03-12 CHM
170	PERÇER la pièce Perçer 4 trous avec un forêt F (Dia. .257 po)	Annexe 1	2015-03-12 CHM
180	DÉCOUPER la pièce Retirer le gabarit de découpe une fois terminé	Annexe 1	2015-03-12 CHM
190	ÉBAVURER les arêtes vives	MPS-300-93- 31-020	2015-03-12 CHM
210	SABLER l'extérieur de la pièce Papier 120 à 320 grains		2015-03-12 CHM
220	NETTOYER les surfaces extérieures		2015-03-09 N98

Section E : FINITION/PEINTURE

230	APPLIQUER le primer	MPS-300-93-31-097	2015-03-12 Noy
240	<u>Inspection finale :</u> • Validation de la finition (pinholes, surface inégale, etc...) • Vérifié s'il y a un panneau de contrôle relié à la pièce • Étamber le carré dans le coin inférieur droit de la deuxième page • Valider l'identification de la pièce	MPS-300-93-31-058	2015-03-13 Inspecteur  Qualité 6-65 LB3
<u>Section F : EXPÉDITION</u>			
250	Emballer et expédier	MPS-300-93-31-084	